

Work Order ID 73395

Wednesday, August 31, 2011 3:04:16 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 8/31/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

CZ

Date: 11/08/31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr if necessary

304 . 063

B11-9-13



110

0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

QC

Quality Control

B11-9-13

120

0.00



QC8- Inspect parts - second check

Memo

0.00

QC

Quality Control

8/16/13

counts
x60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-Identify as D3537-1

SB 11/6/13

60

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch □ A/R 2059B Hardcoat
11/8/07 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any weld that penetrated through Wearpad if necessary

60 11-09-20-JBL

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

S 11/01/20

cut
60

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Start Date: 8/31/2011	Start Qty: 50.00		Cust Item ID:	
Required Date: 9/23/2011	Req'd Qty: 50.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				<i>count</i>			
						<i>760</i>			
QC	Memo	0.00							
Quality Control									

170	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat		0.00							
Powder Coating	Memo								
	START TIME: <i>7:40</i>								
	FINISH TIME: <i>8:10</i>								
	OVEN TEMPERATURE:								
	<i>320°F</i>								
180	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

W117338

60X Ø M-L 11/09/21

60 BR 11-9-21

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: F-P 2

0.00



Packaging

Memo

0.00

Packaging

60x4 m / 11/9/21

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/9/21**MF**11-09-21*

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Picklist Print

Wednesday, August 31, 2011 3:04:14 PM

Page 1

Work Order ID: 73395

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 8/31/2011

Required Date: 9/23/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

129.1000

0.106

5.578947

6.5



FB119-13

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

118217

60

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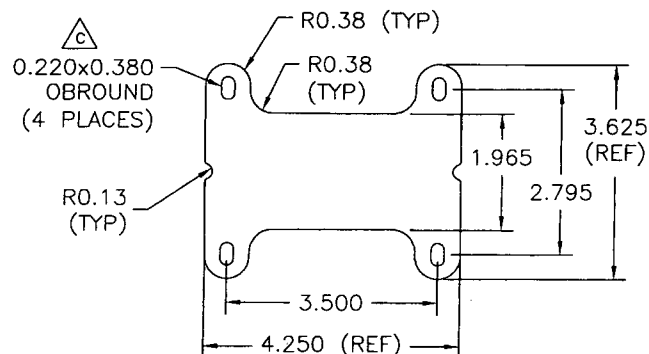
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

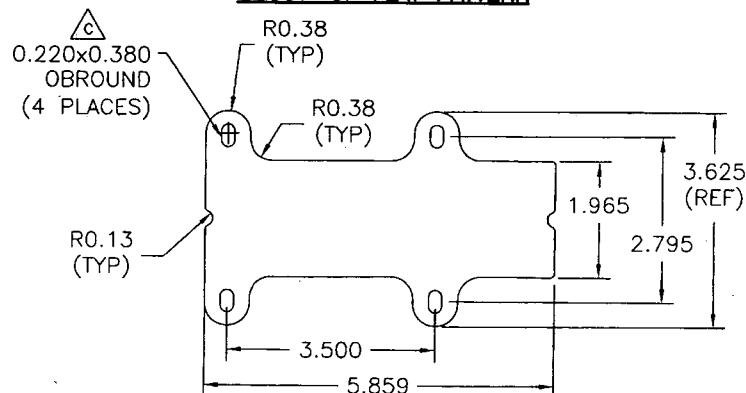
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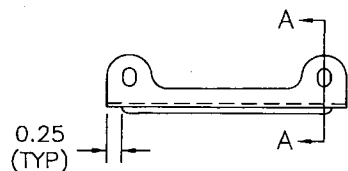
D3537-1F FLAT PATTERN



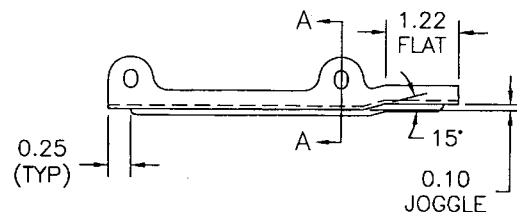
D3537-3F FLAT PATTERN



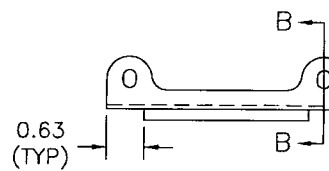
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)

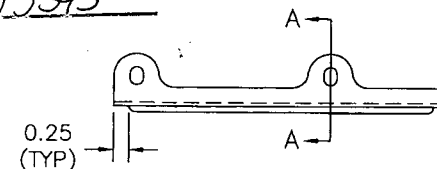


D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

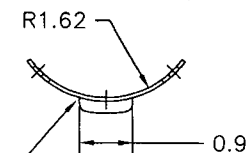


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 73395

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

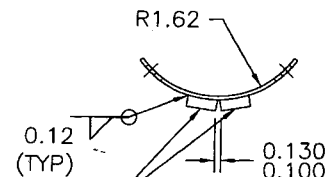


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.03 Ad
per ECN
962

D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED	4	APPROVED	4	DRAWING NO.	D3537	REV. C	SHEET 1 OF 1
DATE	07.04.13	TITLE	WEARPAD	SCALE			1:2

W/O:		WORK ORDER CHANGES					
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